

Work Order ID 123295

August-07-14 7:50:26 AM

123295

Page 1

Item ID: D4463-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tank Upper Cut Out
 Start Date: 8/07/14 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 8/08/14 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4463	D								
100		0.00							DAS 23 9-89 14-08-7
100									
Waterjet									
FLOW CNC Waterjet									
	Memo	0.00							
	Cut as per dwg								
	Prog rev: <u>D</u>								
	Dwg rev: <u>D</u>								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 23 9-89 14-08-7
110									
QC									
Quality Control	Memo	0.00							

120	QC8- Inspect parts - second check	0.00							DAS 38 9-89 14/08/07
120									
QC									
Quality Control	Memo	0.00							

August-07-14 7:50:26 AM

1 23295

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 8/07/14 **Start Qty:** 6.00 ***6***

Cust Item ID:

Required Date: 8/08/14 **Req'd Qty:** 6.00 ***6***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC7-Inspect.Chemical Conversion Coal

0.00

160

OC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 0.00

0.00

170

Packaging

Memo

WAZ

0.00

Packaging

180

QC21- Final Inspection - Work Order Release	0.00
---	------

0.00

180

QC

Memo

0.00

Quality Control

6 Q (2P) 14/09/02

14/9/2 6

MLJ 14-09-03

MLJ 14-09-03

Picklist Print

August-07-14 7:50:26 AM

Page 1

Work Order ID: 123295

123295

Parent Item: D4463-5

D4463-5

Parent Item Name: Tank Upper Cut Out

Start Date: 8/07/14

Required Date: 8/08/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

100

sf

840.0880

0.174

2

DAS

M6061T6S 063

**

23

9-89

14-08-7

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

584.088

M127420

111.12

M128054

63.468

M128941

28

M129636

183

M129845

81.5

M129881

117

TPI

256

M129637

256

129845

DART AEROSPACE LTD

Work Order:

~~171634~~

Description: Tank Upper Cut Out

Part Number:

D4463-5

Inspection Dwg: D4463

Rev: ~~0~~

DC 7/14/2017

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

DAS

DAS

Measured by:

23
9-89

Audited by:

38
9-89

Preliminary Approval:

Date:

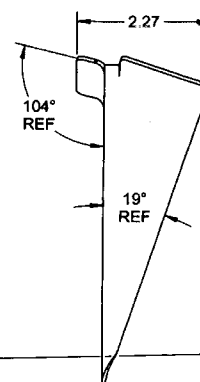
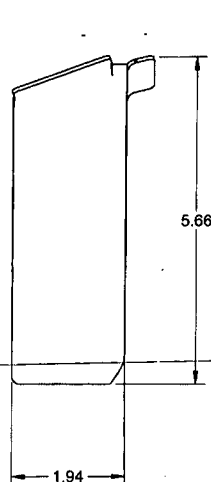
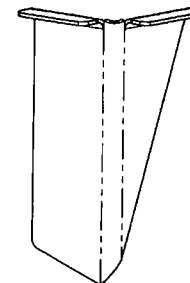
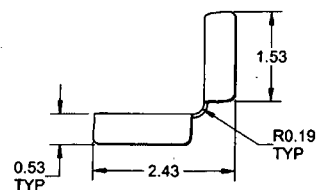
14-08-7

Date:

14/08/07

Date:

Rev	Date	Change	Revised by	Approved
A	12.02.01	New Issue	KJ	
B	13.09.17	Dwg Rev updated	KJ	



D4463-5 TANK UPPER CUT OUT

NOTES:

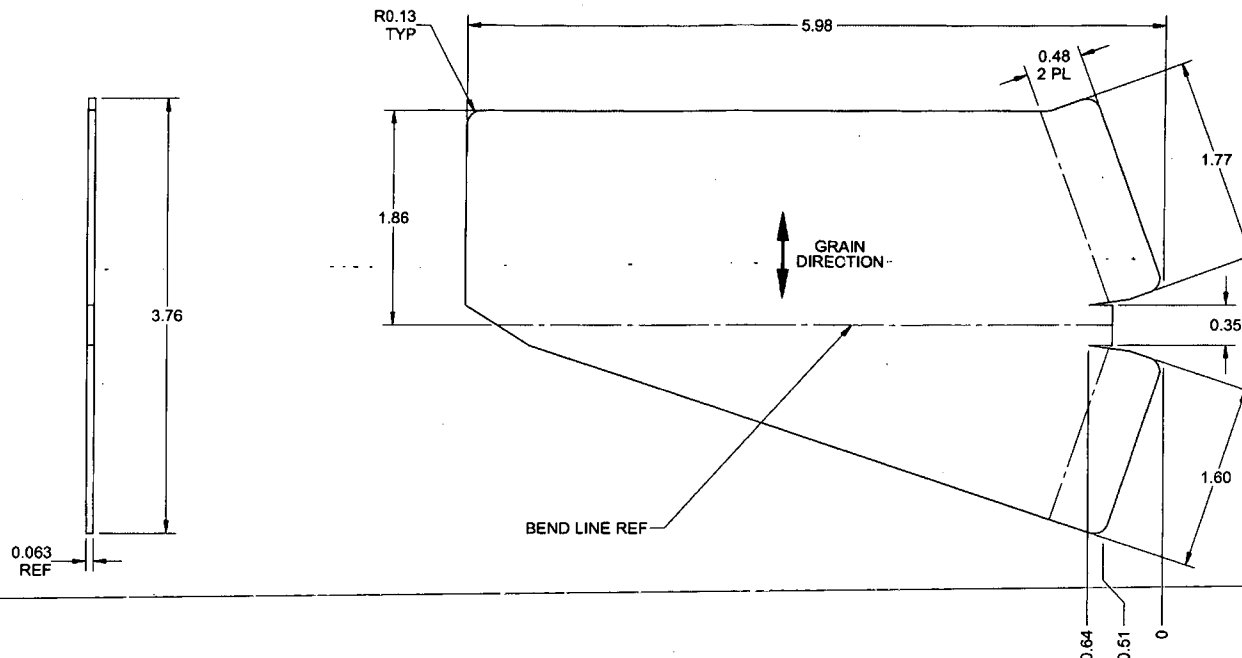
- 1) MATERIAL: MADE FROM D4463-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	ML	
CHECKED	AP	DRAWING NO. REV. D
MFG. APPR.	JLM	D4463 SHEET 5 OF 14
APPROVED	MP	TITLE SCALE
DE APPR.	DS	AUX TANK NTS
DATE	14.05.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 121029 MJS
123295 14-06-17
u

RELEASED
2014-06-11



D4463-5F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILE "D4463-5F-D.DXF"

APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4463	SHEET 8 OF 14
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	AUX TANK	NTS
DATE	14.05.13	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
2014-06-11